

Date: Monday, 06/10/2008 10:45:02 AM  
User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	STUD
<b>Job Number</b> :	42446		
<b>Estimate Number</b> :	10543		
<b>P.O. Number</b> :		<b>Part Number</b> :	D30281
<b>This Issue</b> :	06/10/2008	<b>Drawing Number</b> :	D3028 REV A
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	11	<b>Drawing Revision</b> :	A
<b>Previous Run</b> :	33369	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	30/10/2008
<b>Checked &amp; Approved By</b> :	<u>JULIO 08.10.06</u>	<b>Qty:</b>	20
<b>Comment</b> :	Est.B 02.09.10 Made on Cobra KJ	<b>Um:</b>	Each

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NR0750	4130 steel RD bar .750"
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**Comment:** Qty.: 0.1313 f(s)/Unit Total : 2.6250 f(s)  
4130 steel rod .750"

Material: AISI 4130N Bar per MIL-S-6758 or AMS 6348/ 6370/ 6528 Ø0.750"(M4130N-R0.750)

Batch

M109135

Threads per MIL-S-7742

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:**

- 1-Turn blank per Dwg D3028 and FA263
- 2-Cut groove as per Dwg D3028 and FA263
- 3-Deburr and tumble for a short time to prevent damage to threads

*N/A*

08/10/14 *N.A* 08/10/22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

08/10/14 *N.A* 08/10/22

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

08/10/23

5.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
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**Comment:** Sub-Contracting PURCHASING

Issue P/O: 7434

Finish : Cadmium plate per QQ-P-416F Class 1, Type II

Material release note is required.

08/10/23

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 06/10/2008 10:45:02 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STUD

Job Number: 42446

Part Number: D30281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage  
Ensure Material Release Note is attached  
Identify and Stock  
Location: 5760

*Signature* (20)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/06 *Signature*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-11-05

6.1 QC21 Sooluloy (x20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

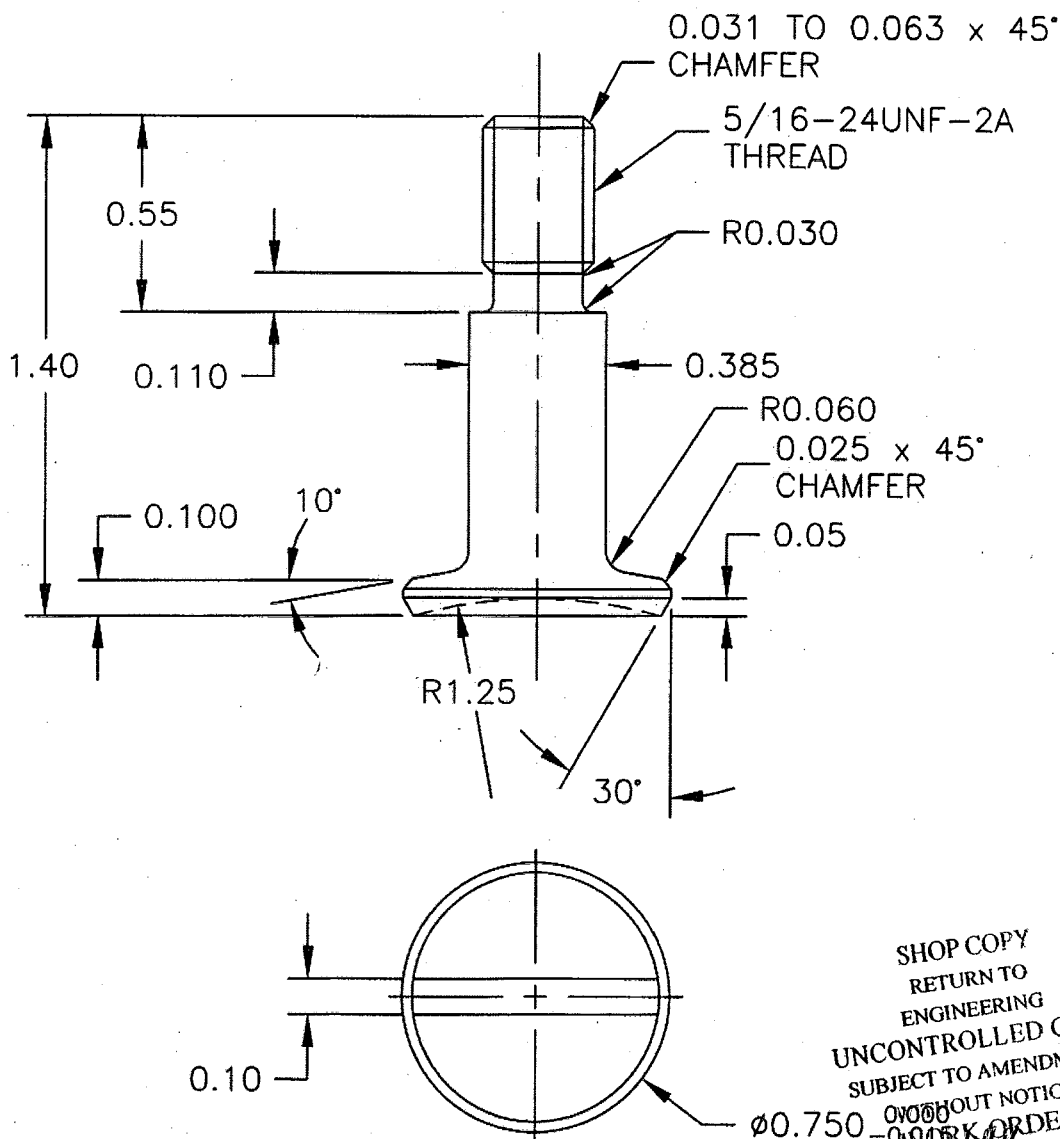
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3028	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE STUD	SCALE 2:1
A	01.05.18	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING



D3028-1:

- 1) POSSIBLE SUPPLIER: NORTHERN AERO INDUSTRIES P/N B83602-1
- 2) MATERIAL: AISI 4130N BAR PER MIL-S-6758 OR AMS 6348/6370/6528
- 3) THREADS PER MIL-S-7742
- 4) FINISH: CADMIUM PLATE PER QQ-P-416F CLASS 1, TYPE II
- 5) ALL DIMENSIONS ARE IN INCHES.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40446

RELEASED  
01.05.30

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42446
<b>Description:</b> 5120		<b>Part Number:</b> 23028-1
<b>Inspection Dwg:</b>		<b>Rev:</b>
		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.40	$\pm 0.30$	1.393	/			
.55	$\pm 0.30$	.556	/			
.110	$\pm 0.10$	.105	/			
.100	$\pm 0.10$	.100	/			
.05	$\pm 0.30$	.05	/			
.025x45°	$\pm 0.10 \pm .5^\circ$	.025x45°	/			
R.060	$\pm 0.10$	R.063	/			
.385	$\pm 0.10$	.388	/			
Ø.750	$\pm 0.000$ $\pm 0.15$	Ø.747	/			
.10	$\pm 0.30$	0.095	✓			Milling operation
M.O.W.	Min. .3315 Max. .3352	.332	/			
5/16-24 UNF 2A)	Min. .3042	.307	/			
Thread						
Major dia.	Max. .3114					
R1.25	$\pm 0.30$	R1.25	✓			
0.05	$\pm 0.30$	0.049	✓			

<b>Measured by:</b> SA/BA	<b>Audited by:</b> SP	<b>Prototype Approval:</b> N/A
<b>Date:</b> 08/10/22	<b>Date:</b> 08/10/23	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

**MANCO**

8895 Crescent 3

Anjou (Québec) H1J 1B6

**DOMPLEX**

Tél.: (514) 355-7867

Fax: (514) 355-8750

**CERTIFICAT DE CONFORMITÉ**  
**CERTIFICATE OF COMPLIANCE**

# 1167

Client / Customer

Votre # de commande / Your purchase order #

# de la pièce / part #

Notre # de bon de livraison / Our packing slip #

Inspecteur / Inspector	Lennuit			Date, équipe / Date, shift	30/10/09
Placage / Plating	QQP-416 F T-1R # class 1 Soolux				
Quantité totale / Total quantity	1 lot		Quantité inspectée / Inspected quantity	1 lot	
Adhésion / Adhesion	good				
Épaisseur / Thickness	L.C.D.	H.C.D.	Moy. / aver.	0.0005	
Coussures, taches / Leach, spots	NO		Rugosité / Roughness	NO	
Quantité approuvée / Approved quantity	1 lot		Quantité rejetée / Rejected quantity		

Commentaires / Comments

B 33369 = 4 Pcs

B 42446 = 20 Pcs

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Signé au nom de  
Signed on behalf of**MANCO**  
**DOMPLEX**